

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
24 July 2003 (24.07.2003)

PCT

(10) International Publication Number
WO 03/060205 A1

(51) International Patent Classification²: D01D 10/00

(21) International Application Number: PCT/US02/00153

(22) International Filing Date: 3 January 2002 (03.01.2002)

(25) Filing Language: English

(26) Publication Language: English

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(81) Designated States (national): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OM, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZM, ZW.

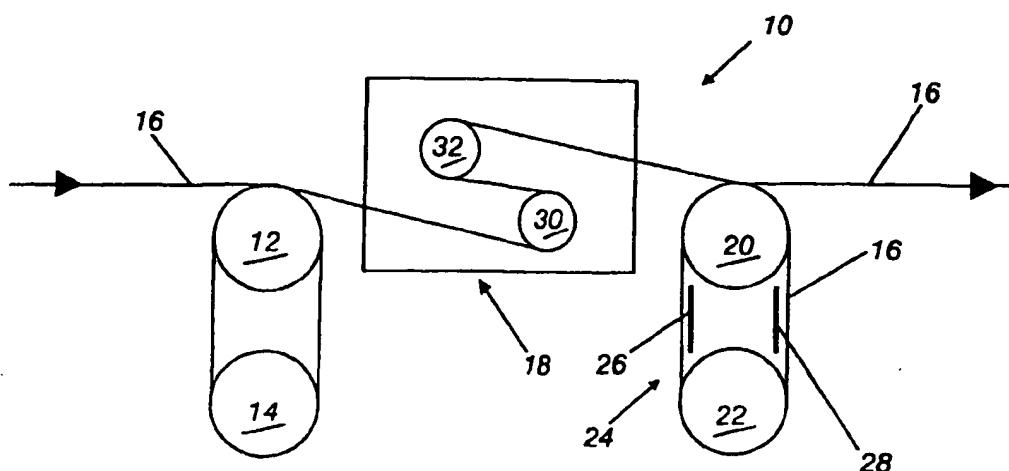
(84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BE, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— with international search report

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: YARN MAKING PROCESS AND APPARATUS



WO 03/060205 A1

(57) **Abstract:** The present invention relates to the combination of a tension gate (18) and an air shield (24) in the relax zone of a fiber production process. The combination provides a synergistic effect over an air shield (24) alone, or a tension gate (18) alone, or the added effect of both a tension gate (18) and an air shield (24). The air shield (24) is a plate like structure with or without perforations. The air shield plates (26, 28) are placed in close proximity to a pair of rolls (20, 22) following the tension gate (18). The plates (26, 28) are positioned inside of the threadline between the pair of rolls (20, 22). The tension gate (18) can be one or more air drag devices, one or more liquid drag devices, or one or more solid surface contact devices, or a combination of any of the above. The apparatus and the process for using the apparatus is disclosed and claimed.